

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001068**Date Inspected:** 10-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Mock-Up				

**Summary of Items Observed:**

Mock-Up OBG

This Quality Assurance Inspector along with Quality Assurance Inspector Scott Croff checked the delta measurements for the actual center line (ACL) to the outer face of the plates of the closed u-ribs for the orthotropic box girder (OBG).

Delta measurement from ACL to outside edge of u-rib plates

U-Rib Weld # End of 13000mm Rib Bolted Connection End of 13000mm U-Rib Weld # End of 1750mm Rib Bolted Connection of 1750mm

U-01 1 1356 1356 U-06 1 1355 1353

U-01 2 1050 1042 U-06 2 1041 1048

U-02 3 756 755 U-07 3 757 755

U-02 4 444 443 U-07 4 444 443

U-03 5 156 154 U-08 5 160 155

U-03 6 156 155 U-08 6 157 157

U-04 7 446 442 U-09 7 444 448

U-04 8 752 755 U-09 8 756 752

U-05 9 1049 1042 U-10 9 1044 1051

U-05 10 1351 1357 U-10 10 1357 1354

1). The readings on the ends were taken by stretching the tape measure across the bottom face of the deck plate

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

with the 0mm mark at the center line punch of the ACL. With the tape measure stretched to the outside edge of the plate, flat against the deck plate bottom facing down a 150mm rule was held along the outside face of the rib so that the tip of the rule extended up and just touched the tape measure and the reading was taken.

2). The readings at the bolted connection end of the ribs were taken at the face of the backing bar 10 mm below the deck plate in a similar manor as the ends. This was done a access did not permit the taking of the readings at the bottom face of the deck as with the ends.

This Quality Assurance Inspector further worked on the spread sheet for quantifying and identifying the location of lack of penetration (LOP) measurements along welds 1 through 10 of the weld trial plate.

### Summary of Conversations:

No conversations held today.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Berger,Bruce
----------------------	--------------

Quality Assurance Inspector
-----------------------------

---

<b>Reviewed By:</b>	Cochran,Jim
---------------------	-------------

QA Reviewer
-------------